User

Wednesday, 1/18/2006 10:28:07 AM

Linda Lacelle

## **Process Sheet**

Customer

: CC-DAR01 Dart Aerospace Ltd.

**Job Number** 

: 25543

**Estimate Number** 

: 10804

P.O. Number

: NIA

This Issue

: 1/18/2006

: NC

Prsht Rev. First Issue

: MH : 00015

: NIA Type

S.O. No. : NIA

Part Number

**Drawing Name** 

: K10007 - RTN 440

**Drawing Number** Project Number

AlM:

Drawing Revision Material

:NIA nin:

: K10007

**Due Date** 

: 1/25/2006

Qty:

1 Um: Each

Written By

Checked & Approved By

Comment

**Previous Run** 

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 440

PACKAGING RESOURCE #1

2.0

1.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

ADD THE FOLLOWING PARTS TO KIT (USED):

4 X D2182B050

4 X D2438

B B23172 B B23818

8 X D2529

B B 25372

B 1719085

8 X AN4-15A 8 X AN4-17A

B 4x m14526/m15432 x4

2 X QS200M44S B 19504

**PAPERWORK** 

Neoprene Cushion-.750 bl

C 206/01/23

3.0

D2182B

Comment: Qty.:

0.4166 f(s)/Unit Total:

0.4166 f(s)

Neoprene Cushion-.750 bl

Clamp

D2438 4.0



Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Clamp

D2529

Washer

5.0

Comment: Qty.:

8.0000 Each(s)/Unit Total:

8.0000 Each(s)

Washer

Wednesday, 1/18/2006 10:28:07 AM Date: User: Linda Lacelle **Process Sheet** Drawing Name: K10007 Customer: CC-DAR01 Dart Aerospace Ltd. Job Number: 25543 Part Number: K10007 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 Bolt AN415A 8.0000 Each(s) Comment: Qty.: 8.0000 Each(s)/Unit Total: Bolt 7.0 AN417A Bolt Comment: Qty.: 8.0000 Each(s) 8.0000 Each(s)/Unit Total: Bolt 8.0 QS200M44S Clamp Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Clamp **INSPECT 100% KITS FOR COMPLETENESS** 9.0 QC4 Comment: INSPECT 100% KITS FOR COMPLETENESS 10.0 PACKAGING 1 PACKAGING RESOURCE #1 **Comment: PACKAGING RESOURCE #1** REPACKAGE PER PPP 11.0 DC Comment: DOCUMENT CONTROL **INSPECT LEVEL 21** Job Completion

48

Description: Bearpaw Kit (19" x 16")

Dwg: D2435 Rev. E1

Page 1 of 1

DC	Step	Location	Procedure	Ву	Date	Qty
Dwg not required	1	DC	Issue Traveler	1.10		
DC				141)	1/2 11 01	ac
D206-559   D500-572   D120-638   D508-678   and create labels per PPP K10007   CHG003   W 46 W 67 W 70 W 70 W 70 W 70 W 70 W 70 W 7				14 X	05.71.06	10
D500-572   D120-638   D058-678   and create labels per PPP K10007   CHG003   IX 46 W   D04.01.15   IO   IO   IO   IO   IO   IO   IO   I	2	DC				
D120-638   D056-678   and create labels per PPP K10007   CHG003   CHG003						
Sag Bluefiles separately   World				12.0	121112	10
Sag Bluefiles separately   World	****	1	· ·		10011110	
Sag Bluefiles separately   World				MX	12/2/15	10
GA			(Reg Physiles approach)	10	04.01.15	
Cut blank: 16.00" x 20.00" x 1.00" thick MIH32C Material: Black UHMW 1" (MUHMWB10) Batch: 44777	2	100		100	·	
Material: Black UHMW 1"	3	GA	Cut blants 40 00% - 90 00% - 4 00% H 1 1	KAG		10
MV   Inspect material for defects or damage prior to machining   MV   Inspect material for defects or damage prior to machining   MV   Machine as per Folio D2435 and Dwg D2435   MV   Machine as per Folio D2435 and Dwg D2435   MV   Deburr   Description   Batch   MV   D2182B050   Rubber Cushion   B19540   MV   MV   MV   MV   MV   MV   MV   M					1	10
Identify as D2435	1			BA	04-01-16	10
MV		`				
MV   Machine as per Folio D2435 and Dwg D2435   MV   Deburr   Deburr   MV   Deburr   MV   Deburr   Deburr   MV   Deburr   Deburr   Description   Deburr   Deburr   Description   Description   Description   Deburr   Description   Descripti	4	MV		Alla .	21/21/-0	112
6 QC2 Inspect parts as they come of the CNC machine  7 MV Deburr  8 QC8 & 5 Second inspection  9 KP Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) Qty Part Number Description Batch 4 D2182B050 Rubber Cushion B19540 8 D2274 Radius Block 619549 B19542 2 D2435 Bearpaw B19645 8 D2529 Washer B20089 A B19615 8 D2529 Washer B20089 A B19615 8 AN4-17A Bolt m13536 M121692 16 AN960JD416 Washer M13719 18 MS21042L4 Nut (or -4)m13276 M13928 m/4312 19 QS200M44S Clamp m14019 M13928 m/4312 10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC Cost / part / 6 Z, Z O  13 DC Close W/O / 5 C, S 7			_	Z CAP)	グルノフ	20
7 MV Deburr  8 QC8 & 5 Second inspection  9 KP Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)  Oty Part Number Description Batch 4 D2182B050 Rubber Cushion B19540 2 D2274 Radius Block 619599 B197922 2 D2435 Bearpaw B1989(c) 4 D2438 Clamp 6 20089 A B1989(c) 8 D2529 Washer 8 200 90 B18930 B1998(c) 8 AN4-15A Bolt M1353(c) M12492 16 AN960JD416 Washer M13719 18 MS21042L4 Nut (or -4)M1327(c) M13928 M19312 19 QC4 Inspect Kit for 100% Completeness on the W/O  10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC  Cost / part / 6 Z, Z O  Suc Over 20 Z O  Suc Over 20 Z O	5	MV	Machine as per Folio D2435 and Dwg D2435	2/6	Offile 9	20
7 MV Deburr  8 QC8 & 5 Second inspection  9 KP Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)  Oty Part Number Description Batch 4 D2182B050 Rubber Cushion B19540 2 D2274 Radius Block 619599 B197922 2 D2435 Bearpaw B1989(c) 4 D2438 Clamp 6 20089 A B1989(c) 8 D2529 Washer 8 200 90 B18930 B1998(c) 8 AN4-15A Bolt M1353(c) M12492 16 AN960JD416 Washer M13719 18 MS21042L4 Nut (or -4)M1327(c) M13928 M19312 19 QC4 Inspect Kit for 100% Completeness on the W/O  10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC  Cost / part / 6 Z, Z O  Suc Over 20 Z O  Suc Over 20 Z O	6	QC2	Inspect parts as they come of the CNC machine	1/9/	26.4	00
8 QC8 & 5 Second inspection  9 KP  Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)  Qty Part Number Description Batch				100	10121	20
9 KP Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)  Qty Part Number Description Batch  4 D2182B050 Rubber Cushion B19540  8 D2274 Radius Block B19542 B19522  2 D2435 Bearpaw B19896  4 D2438 Clamp 6 20089 A B19615  8 D2529 Washer 8 200 90 B18930 B19486  8 NA4-15A Bolt M13-536 M12692  16 AN960JD416 Washer M13-119  18 MS21042L4 Nut (or -4)M13 276 M13-129  19 QC4 Inspect Kit for 100% Completeness on the W/O  10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC  Cost / part / 6 Z, Z O  Close W/O / 5 6, S 7	7		Deburr	P/W	4/1/20	20
Second   Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3)   Qty   Part Number   Description   Batch	8	QC8 & 5	Second inspection	B	64.62.01	20
10   QC4   Inspect Kit for 100% Completeness on the W/O   QC4   Cost / part / 6 Z, Z O   QC4   Clamp B 2008   A R 196/15   A R 196/15	9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in			
10   QC4   Inspect Kit for 100% Completeness on the W/O   QC4   Cost / part / 6 Z, Z O   QC4   Clamp B 2008   A R 196/15   A R 196/15						1
10   QC4   Inspect Kit for 100% Completeness on the W/O   QC4   Cost / part / 6 Z, Z O   QC4   Clamp B 2008   A R 196/15   A R 196/15					11.11	0-1
10   QC4   Inspect Kit for 100% Completeness on the W/O   QC4   Cost / part / 6 Z, Z O   QC4   Clamp B 2008   A R 196/15   A R 196/15		<i>~</i> →		J/W	04/116	20
10   QC4   Inspect Kit for 100% Completeness on the W/O   QC4   Cost / part / 6 Z, Z O   QC4   Clamp B 2008   A R 196/15   A R 196/15		}	A	9		
8   D2529   Washer B200 90 B18930 B19486   Na. AN4-15A   Bolt   m13437   Na. AN4-17A   Bolt   m13536   m121692   Na. AN960JD416   Washer   m13719   Na. MS21042L4   Nut (or -4)m13276   m13928 m14312   Na. AN960JD416   Nut (or -4)m13276   Nu		_,		1 4		l
National   National	ļ			. I		]
Name	ļ		***	<b>3</b> 6	ļ	
16 AN960JD416 Washer	ľ		<del></del>			1
8 MS21042L4		3	12 1 14 W. A. Com			
10   QC4   Inspect Kit for 100% Completeness on the W/O   11   PK   Identify and pack for shipping as per PPP K10007   12   AC   Cost / part /6 Z, Z O   540   64-62-63   Z O   13   DC   Close W/O / 56, 5-7   1.0		\]	· · · · · · · · · · · · · · · · · · ·		İ	
10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC  13 DC Close W/O ( \$5.5.7)  14 PAPerwork package from Step 2		d.		1421	,	1
10 QC4 Inspect Kit for 100% Completeness on the W/O  11 PK Identify and pack for shipping as per PPP K10007  12 AC Cost / part /6 Z, Z O  13 DC Close W/O / 5 6, 5 7		(		,,,,,,		
11 PK Identify and pack for shipping as per PPP K10007  12 AC Cost / part / 6 Z, Z 0  13 DC Close W/O / 5 6, 5 7	10	QC4		0	04-02-02	20
12 AC Cost/part /6 Z, Z O Syc 64-62-03 Z O	11	PK	Identify and pack for shipping as per PPP K10007	<i>√</i> 2.		
Cost / part /62, 70 5 45 04-02-03 Zo  13 DC Close W/O / 56, 5-7	12	AC		W/V	17.00 VX	oc U
13 DC Close W/O 156,57			Cost/part /62, 20	540	04.02.03	20
Inspect Level 21 / Hylo4. 02.03   20	13	DC	Close W/O 156,57			1
			Inspect Level 21	14	04.02.03	201

Rev	Date	Change	Revised By	Approved
Α	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC .	
В	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	4
С	01.11.08	Revised Step 3 and Added Level 21	SM	1
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	

BB0402-63

03.03.31 7